

Work Order ID 58422

May 6, 2010 2:42:25 PM



Page 1

Item ID: D2175-2	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Angle RH					
Start Date: 06/05/2010	Start Qty: 6.00		Cust Item ID:		
Required Date: 13/05/2010	Req'd Qty: 6.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>PL</u>	Date: <u>10-5-06</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2175	Rev E								

100	FLOW WATER JET	0.00							
	Waterjet								
Flow CNC Waterjet	Memo	0.00							
2004.063	1-Cut as per Dwg D2175 <input type="checkbox"/> Dwg Rev: <u>E</u> <input type="checkbox"/> Prog Rev: <u>E</u> <input type="checkbox"/> 2- Deburr if necessary								

B10-6-1

(12)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

B10-6-1

120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

810661

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2175-2

Accept



Setup Start



Revision ID:

Item Name: Angle RH

Stop



Start Date: 06/05/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr Stack								
140		0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Form as per Dwg D2175								
150		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

n/a 8

SD 10/06/09

12

SD 10/06/09

412

-2

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Item ID: D2175-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle RH

Start Date: 06/05/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

12 BR 10-6-10.

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

OH 10/06/10

12 0

180

Identify as per dwg & Stock Location: 304

0.00



Packaging

Memo

0.00

Packaging

10-6-10 SP (12k)

W/O:		WORK ORDER CHANGES					
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Item Name: Angle RH

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Start Date: 06/05/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/11 *[Signature]*
mf
10-6-10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 58422



Parent Item: D2175-2



Parent Item Name: Angle RH

Start Date: 06/05/2010

Required Date: 13/05/2010

Comments: IPP ☐ E ☐ 04.06.09 ☐ Reformat ☐ KJ/RF ☐
IPP Rev:F 06-04-28 Manufactured on Water Jet JLM
IPP Rev:G As per Rev E 06-11-22 JLM

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
M2024T3S.063		Purchased	No			100	sf	172.5000	0.4722	3.2		
2024-T3 .063 sheet												

1310-6-1

Location	Loc Qty	Loc Code
MAT22	172.5	
111787	2	
113866	19.2	
113867	19.1	
114351	132.2	

111787 x6 2.8
114351 x6 2.8
5.6

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	38422
Description: Angle		Part Number:	D2175-1/-2
Inspection Dwg: D2175	Rev: E	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.650	+/-0.010	12.650	✓			
R0.35	+/-0.030	.35	✓			
2.915	+/-0.010	2.916	✓			
50°	+/-0.5°	50°	✓			
0.300	+/-0.010	.300	✓			
1.050 Pitch	+/-0.010	1.048	✓			
10.500	+/-0.010	10.499	✓			
11.550	+/-0.010	11.550	✓			
0.550	+/-0.010	-.548	✓			
0.900	+/-0.010	-.904	✓			
0.063 thick	+/-0.010	.062	✓			
Grain Direction	N/A	✓	✓			
Ø0.128	+0.005/-0.001	.129	✓			
Ø0.172	+0.005/-0.001	-.172	✓			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-6-1	Date: 10/6/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.03.23	Dimensions revised per Dwg rev. E	KJ/JLM	

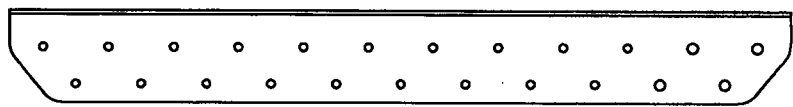
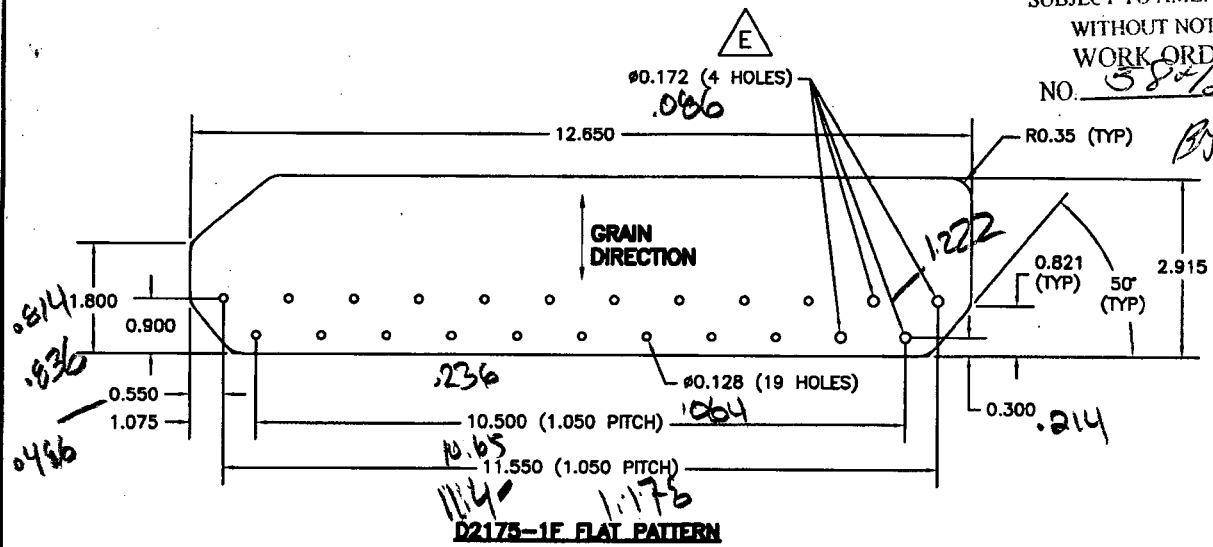


RELEASED
06.10.13

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58422

10-5-06

DESIGN	DRAWN BY	DART AEROSPACE LTD
RF	CE	HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2175
DATE 06.09.25	TITLE ANGLE	REV. E SHEET 1 OF 1 SCALE 1:3
A	95.10.25	NEW ISSUE
B	96.01.18	CHANGED DIMENSION
C	00.09.11	UPDATE FINISH SPEC
D	04.06.03	RE-DESIGN
E	06.09.25	INC HOLE DIA TO Ø0.172, 4 HOLES



**D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)**

- NOTES:
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 5) ALL DIMENSIONS ARE IN INCHES

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